

# Work Order ID 71210

Thursday, June 23, 2011 3:19:57 PM



Page 1

Item ID: D3508-3

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 6/24/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-06-23 Tooling:

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3508	Rev C								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3508 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-  
Deburr if necessary

384.040

B11-7-4

(14)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-7-4

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/6/2/04

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Stop



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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Brake NC

Brake NC

NC BRAKE

Memo

0.00

0.00

1-Form on brake using DT8326 and DT8261 as per Dwg D3508 2-Form joggle as per Dwg D3508 Using DT8158

SB 1167105

14

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/10/05

214

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

0.00

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

8:00

8:30

3200F

14X 11/07/06

M115128

W/O:		WORK ORDER CHANGES					
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Page 3

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Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 6/24/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

14 0 BL 11-7-6

170

Identify as per dwg & Stock Location *FP-21*

0.00



Packaging

Memo

0.00

Packaging

14 0 BL 11-7-6

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/06  
MF 11-07-06

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**NOTE:** Date & initial all entries


Thursday, June 23, 2011 3:19:49 PM

[illegible][illegible]

**Required Date:** 6/30/2011

**Required Qty: 12.00**

**Comments:** IPP Rev:A New Issue 06-06-20 JLM  
IPP Rev:B Now SS as per Rev B 06-12-15 JLM  
IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	228.6630	0.734	9.271579	10.8		
													
304/316 .040 Sheet													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		228.663							
					116623	0.2							
					117550	9.363							
					117933	219.1							
										117933			

W/O:		WORK ORDER CHANGES					
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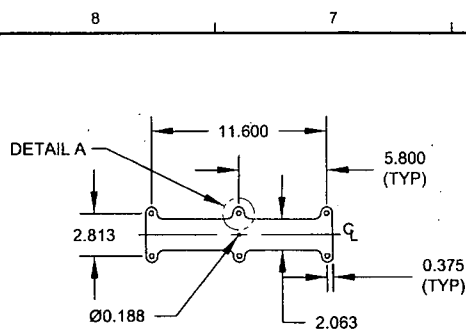
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

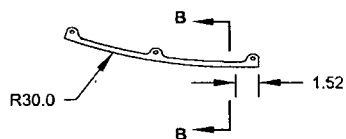
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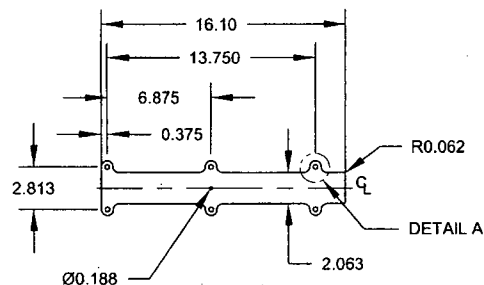




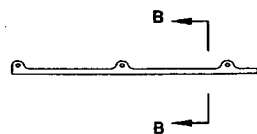
**D3508-1 FLAT PATTERN**



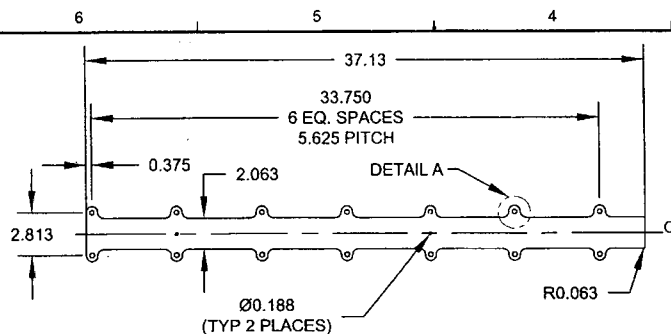
**D3508-1 BENDING DETAIL**  
(MAKE FROM D3508-1F)



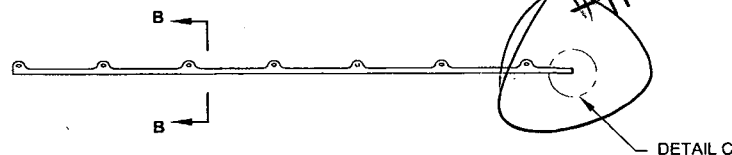
**D3508-7F FLAT PATTERN**



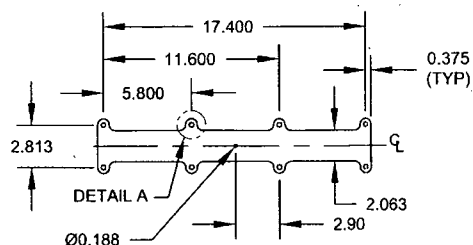
**D3508-7F BENDING DETAIL**  
(MAKE FROM D3508-7F)



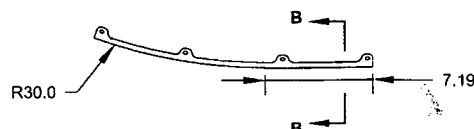
**D3508-3 FLAT PATTERN**



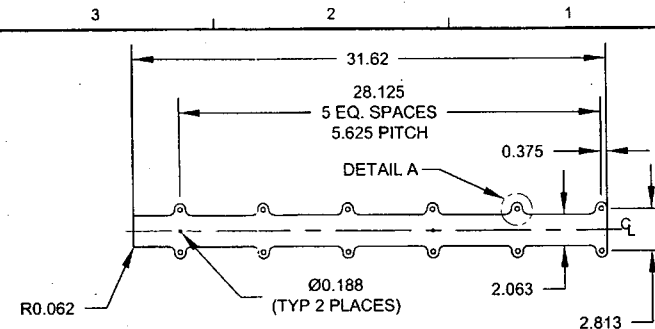
**D3508-3 BENDING DETAIL**  
(MAKE FROM D3508-3F)



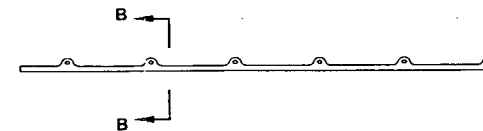
**D3508-9F FLAT PATTERN**



**D3508-9F BENDING DETAIL**  
(MAKE FROM D3508-9F)



**D3508-5 FLAT PATTERN**



**D3508-5 BENDING DETAIL**  
(MAKE FROM D3508-5F)

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,  
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs  
D3508-13 - 0.25 lbs

**RELEASED**  
07.11.16

C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	24	<b>DART AEROSPACE USA, INC</b>	
DRAWN	24	PORT HADLOCK, WA	
CHECKED	24	DRAWING NO.	REV. C
MFG. APPR.	24	D3508	SHEET 1 OF 2
APPROVED	24	TITLE	SCALE
DE APPR.	24	WEARPLATE	1:8
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

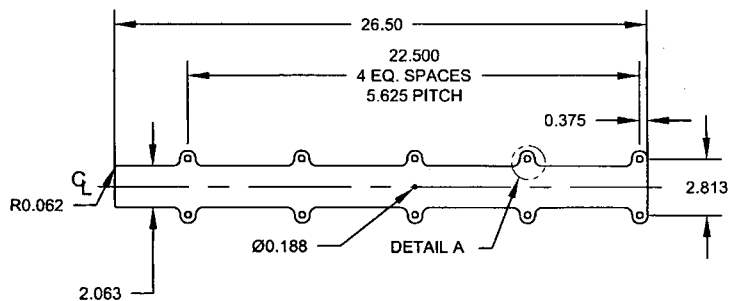
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

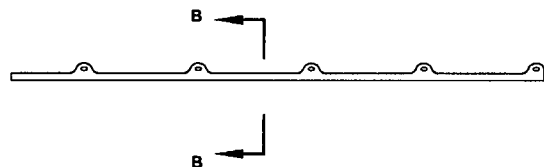
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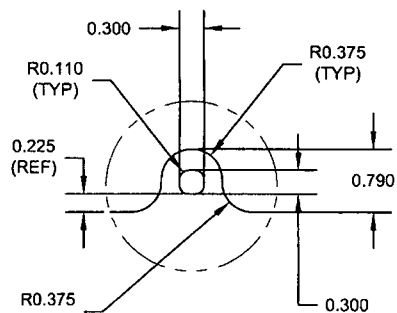
**NOTE:** Date & initial all entries



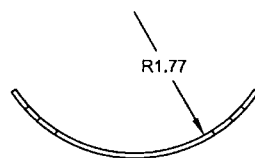
**D3508-11F FLAT PATTERN**



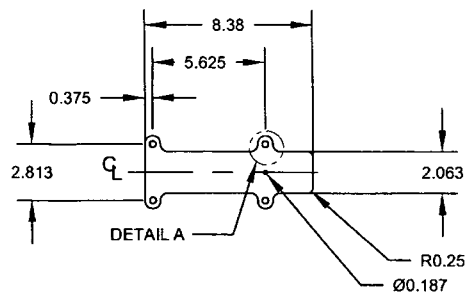
**D3508-11 BENDING DETAIL**  
(MAKE FROM D3508-11F)



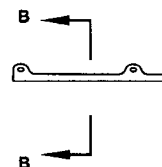
**DETAIL A**  
(SCALE 2:3)



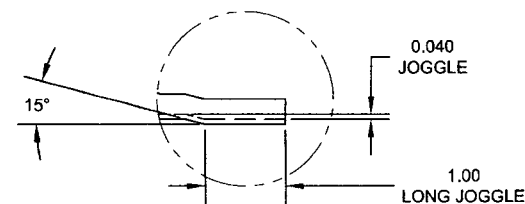
**SECTION B-B**  
(SCALE 2:3)



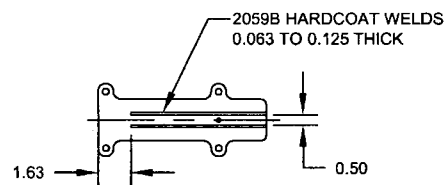
**D3508-13F FLAT PATTERN**



**D3508-13 BENDING DETAIL**  
(MAKE FROM D3508-13F)



**DETAIL C**  
(SCALE 1:2)



**D3508-13 WELDING DETAIL**

RELEASED  
07-11-16

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
DATE	07.04.20	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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